



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3205-00T
Job Sheet 191529



Part No: RBE350A93-3205-00T

Job Qty: 4 pcs

Part Name: Tail Rotor Gear Box Input Flange Holding Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/4/19

Job Tracking No:

Due Date: 4/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A93-3205-00T Rev 3C IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Waterjet - Omax - 1	4 pcs	4/18/19	4/18/19	0.00	0.40	Waterjet - Omax	dc 19/04/02
110	QC 2	4 pcs	4/18/19	4/18/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	dc 19/04/02
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	

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120	NV5000 - 2 - B4B	4 pcs	4/18/19	0.00 1.00	QC 2 - 64	
					NV5000 - 1 - B4B	SC 19-04-04
130	QC 2	4 pcs	4/18/19	0.00 0.00	NV5000 - 2 - B4B	
					QC 2 - 1	105 19-04-04
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 54	
					QC 2 - 56	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
140	QC 8	4 pcs	4/18/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
170	Outsource - 4 - Anodize	4 pcs	4/18/19		ATG001-VC	10 04/12/2019 PL
180	Packaging 2-1 - Receive - B4B	4 pcs	4/18/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	

				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP APR 22 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
190 QC 6	4 pcs	4/18/19	0.00 0.00	QC 6 - 42	DAS
				QC 6 - 9	APR 22 2019 40
				QC 6 - 68	9-89
				QC 6 - 61	DAS
200 Small Fab - 2 - B4B	4 pcs	4/18/19	0.00 0.33	Small Fab - 1 - B4B	71
				Small Fab - 2 - B4B	9-89
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
205 QC 5	4 pcs	4/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	

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				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
206	Packaging 3-1 - Stock - B4B	4 pcs	4/18/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
210	QC 21 - FG	4 pcs	4/18/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

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MAY 13 2019

Part Op 100 - OMAX (Waterjet 2) 1-Cut as per Dwg Dwg Rev: 3C Prog Rev: 3C 2-Deburr if necessary
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - NV5000-2 (MORI SEIKI VERTICAL MACHINE #2) 1-Machine as per folio FB744 FOLIO REV: _____ DWG
 REV: _____ 2-Deburr 3-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

170 - Issue P/O to ATG: 044190 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water
 sealant As Per Dwg RBE350A93-3205-00T Rev/ 3C

180 - (Receive & Inspect for Damage & Mat'l Certs)

190 - (QC6- All purchased or subcontracted products)

200 - (Small Fab) Pick, bag and tag

205 - (QC5- Inspect part completeness to step on W/O)

206 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.250	6061T6 Sheet .250	1.4000 sf (.35 ea)	100-Waterjet - Omax - 1	S138977
AN315-5	Nut	12 Ea (3 ea)	200-Small Fab - 2 - B4B	S084127
AN5-7	Hex Head Cap Screw	12 Ea (3 ea)	200-Small Fab - 2 - B4B	S084124
NAS1149F0563P	Washer	12 Ea (3 ea)	200-Small Fab - 2 - B4B	S098031

over 007
over 009
st262

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	M6061T6S.250	1	65	0
200-Small Fab - 2 - B4B	AN315-5	12	0	0
	AN5-7	12	151	0
	NAS1149F0563P	12	461	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD	Work Order:	191529
Description: Tail Rotor Gear Box input Flange Holding wrench	Part Number:	
Inspection Dwg: RBE260A93-3205-001 Rev: 3C		Page 1 of 1

INSPECTION SHEET

[illegible]

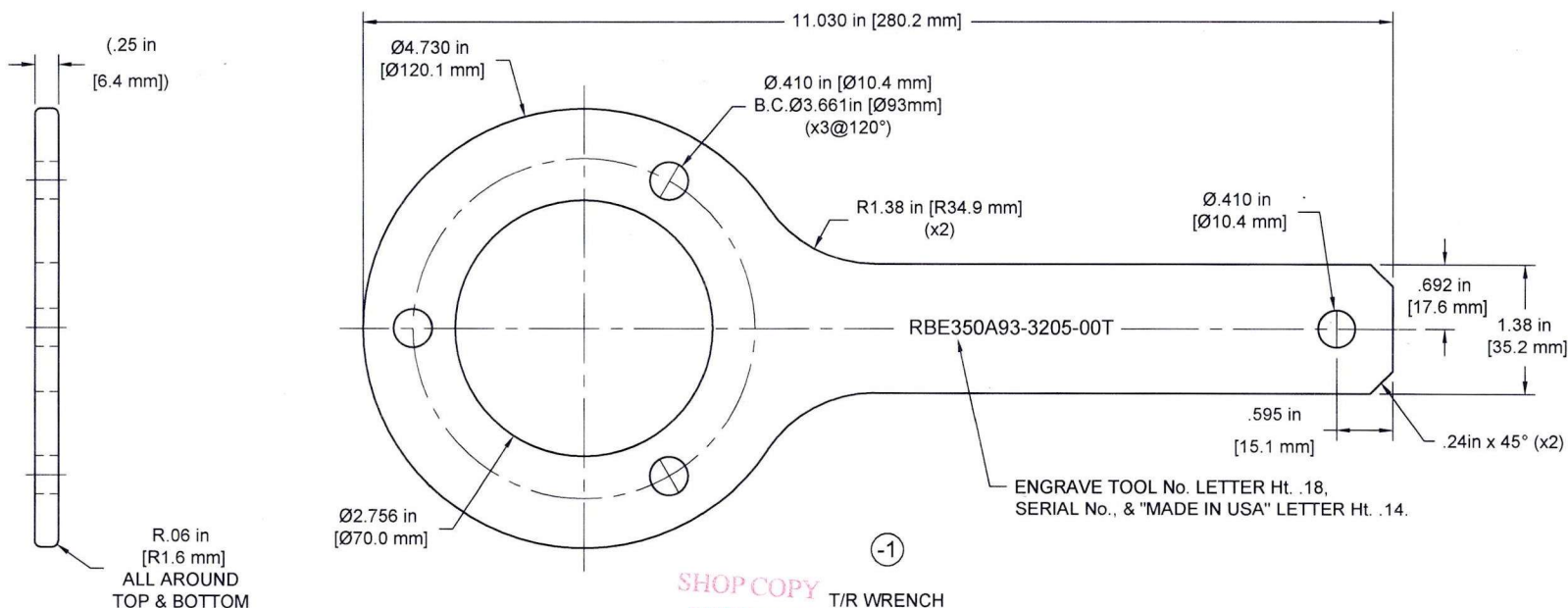
Measured by:	<i>de/s.c.v</i>	Checked by:	<i>Amf</i>	QC Inspector:	
Date:	<i>19/04/02</i>	Date:	<i>19/04/10</i>	Date:	

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED FLAT WASHER AND CHANGED FROM LOCK NUT TO REGULAR NUT PER SAMPLE. ALSO ADDED ENGRAVING NOTE FOR S/N ECT.	5/12/09	WP	RW
2	CHANGED -01 WRENCH HOLES FROM Ø.410 TO Ø.402, AND HANDLE .236 CHAMFERS TO R.197. ALSO ENLARGED -01 CENTER HOLE FROM Ø2.756 TO Ø2.768 PER HELI PRODUCTS TOOLS. A "T" WAS ADDED TO THE END OF THE TOOL No. TO IDENTIFY THE DIFFERENCE FROM THE ENGINE FLANGE WRENCH.	9/29/09	WP	DW
3	REMOVED ALL OF REV. 2 CHANGES.	2/17/10	WP	G.E.
3A	ADDED MISSING R.063 ALL AROUND TOP & BOTTOM DIM. PER G.E. CH'D FLAT WASHER P/N FROM AN960-616 TO AN960-516.	2/19/10	RJC	RW
3B	CORRECTED FINISH SPEC, CH'D BOM FROM -00T TO -1 PER R.W.	2/18/11	RJC	RW
3C	CORRECTED T/N WAS RBEA93-3205-00T IS RBE350A93-3205-00T. CH'D DIMENSION PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS.	11/5/13	RJC	RW



FUNCTION: USED TO HOLD TGB INPUT FLANGE DURING INPUT SHAFT NUT REMOVAL OPERATION.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191529
19-03-04

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
		-1	1	1	T/R WRENCH	6061	1/4 x 4-3/4 x 11-1/8
		B/O	3	3	HEX HEAD CAP SCREW	STEEL	5/16-24 UNF x 31/32 AIRCRAFT SPRUCE #AN5-7
		B/O	3	3	NUT	STEEL	5/16-24 UNF AIRCRAFT SPRUCE #AN315-5
		B/O	3	3	FLAT WASHER	STEEL	Ø5/16 I.D. AIRCRAFT SPRUCE #AN960-516
ASSY #							

RED BARN MACHINE	
TITLE TAIL ROTOR GEAR BOX INPUT FLANGE HOLDING WRENCH	
DWG NO. RBE350A93-3205-00T	REV 3C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS .XXX ± .005 FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-22-08 SHEET 1 of 1
DRAWN BY: PERRITT APPROVED: <i>D. Med</i> HEAT TREAT: BLACK ANODIZE FINISH: MIL-A-8625F, TYPE II, CLASS II USED ON MODEL: EUROCOPTER AS350/355	

FB744

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART
AEROSPACE

Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S168994



Part: RBE350A93-3205-00T

Job No: 191529

Serial No/Batch: S168994

Revision: 3C

Inspector:

Exp Date:

Instructions:

Date: 04/02/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043190



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043190

PO Date: 4/12/19

Due Date: 4/18/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191529	RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3205-00T Rev/ 3C	Firmed	-	4/18/19	8 pcs	0 pcs	8 pcs	\$5.00/pcs	\$40.00

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Line Item Note ** NEED BACK APRIL 18,2019 **

2	188431	RBE350A93-3302-02-5	Extension Handle -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	4/18/19	10 pcs	0 pcs	10 pcs	\$5.00/pcs	\$50.00
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Line Item Note ** NEED BACK APRIL 18,2019 **



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043190



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	191832	D5155-11	Co-Pilot Collective Head (212) : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1), ISSUE P/O: ANODIZE BLACK AS PER MIL SPEC AND DWG C OF CO IS REQUIRED	Firmed	-	4/18/19	6 pcs	0 pcs	6 pcs	\$5.00/pcs	\$30.00
Line Item Note ** NEED BACK APRIL 18,2019 **											
4	191282	RBW2805G00131-3G-1	Slide (Outsource process- Anodize per QSI017 4.1.10.1)-Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL- A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	4/18/19	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
Line Item Note ** NEED BACK APRIL 18,2019 **											
Grand Total:										\$240.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/15/19 11:26 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(018485-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

018485- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
17-Apr-2019		SPARTAKOS BOUNTOURIS		PO043190				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3205-00T Rev.	RBE350A93-3205-00T ANODIZE BLACK PER MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	8	8	0	0	0
2	RBE350A93-3302-02-5 Rev.	RBE350A93-3302-02-5 - ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	10	10	0	0	0
3	D5155-11 Rev.	D5155-11 01-ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	6	6	0	0	0
4	RBW2805G00131-3G-1 Rev.	RBW2805G00131-3G-1 01-ANO-CLEAR [ANODIZE CLEAR]	ANODIZE CH	6	6	0	0	0

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Notes Additionnelles / Additional Notes

big box
small box

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.